

5/22

Split - A

DART AEROSPACE LTD	Work Order:	23190
Description: Pedal Assembly	Part Number:	D3204-041
Dwg: D3204 Rev. A	Qty:	4 Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Travelers for: D3204-041 Pedal Assembly D3204-1 Tube D3204-7 Bushing Dwg not required	Batch 23190 23190 23190	JF	05.07.6 4
2	MV	Cut blank: 2.00" x 0.50" x 6.520" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.500x02.000) Identify for D3204-3	Batch: M11037	SD	05.07.07 10
3	MV	Cut blank: 1.25" x 0.375" x 3.370" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.375x01.250) Identify for D3204-5	Batch: M7321	SD	05.07.07 10
4	MV	Cut blank: 1.00" x 0.500" x 1.150" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.500x01.000) Identify for D3204-11	Batch: M110973	SD	05.07.07 10
5	MV	Cut blank: 2.000" x 0.375" x 3.100" long Bar Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.375x02.000) Identify for D3204-9	Batch: M15185	SD	05.07.07 10
6	MV	Machine D3204-3 as per Folio FA344 and Dwg D3204 Identify as D3204-3		SD	05.07.07 10
7	QC2	Inspect parts as they come off the CNC machine		SD	05.07.07 10
8	MV	Deburr		SD	05.07.07 10
9	QC8	Second check		EG	05.07.08 10
10	MV	Machine D3204-5 as per Folio FA344 and Dwg D3204 Identify as D3204-5		SD	05.07.08 10
11	QC2	Inspect parts as they come off the CNC machine		SD	05.07.08 10
12	MV	Deburr		SD	05.07.08 10
13	QC8	Second check		EG	05.07.08 10
14	MV	Machine D3204-11 as per Folio FA357 and Dwg D3204 Identify as D3204-11		SD	05.07.08 10
15	QC2	Inspect parts as they come off the CNC machine		SD	05.07.08 10
16	MV	Deburr		SD	05.07.08 10
17	QC8	Second check		BL	05.07.08 10
18	MV	Machine D3204-9 as per Folio FA357 and Dwg D3204 Identify as D3204-9		BL	05.07.09 10
19	QC2	Inspect parts as they come off the CNC machine		BL	05.07.09 10

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	23190
Description: Pedal Assembly	Part Number:	D3204-041
Dwg: D3204 Rev. A	Qty:	4

Page 2 of 2

Step	Location	Procedure	By	Date	Qty
20	MV	Deburr	RG	05.07.09	10
21	QC8	Second check	CR	05.07.09	10
22	WA	Cut (2) D3204-13 per Assembly Cut blanks as per Dwg D3204 Material: 6061-T6 (QQ-A-250/11) 0.125" thick (M6061T6S.125) Identify as D3204-13	M15120 Batch: M17695	CPL	05.07.14 10
23	WA	Grind hypotenuse side		CPL	05.07.14 10
24	WA	Weld assembly as per Dwg D3204 using Jig D3204-041T1 Pick: D3204-1 B23190 B23524 Qty Part Number Description Batch 1 D3204-1 Tube -3 B21783 B23190 Identify as D3204-041 -5 B21783 B23190 -9 B21783 B23190 -11 B23190		CPL	05.07.14 10
25	QC5/9	Inspect weld	DD	05/07/14	10
26	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05.07.14	10
27	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 D3204-041 Note: Cover holes for bushing	FC	05/07/14	10
28	QC3	Inspect Powder Coat	SD	05/07/14	10
29	GA	Install D3204-7 bushing as shown in Dwg D3204 Pick: Qty Part Number Description Batch 2 D3204-7 Bushing 22928 B21782	SB	05/07/15	7
30	QC5	Inspect work to Step 29	AD	05/07/15	7
31	ST	Identify and Stock D3204-041 Qty: 3 D3204-1 Qty: _____ D3204-7 Qty: _____ Note: D3204-1/-7 are stocked in welding cell	DC	05/07/21	7
32	AC	Parts to Stock and Prorate Cost to parts per Step 31 Cost / part 172.62 / 172.62	AR	05/07/21	3
33	DC	Close W/Order and Ensure Travelers attached Inspect Level 21 Travelers: D3204-041 D3204-1 D3204-7	EP	05/07/27	3

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	
B	04.06.09	Added Travelers	KJ/RF	RF

RELEASED

HF 04.06.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05/07/06	24	Permanent change	u			le	B 05/07/06
05/07/15							

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	Z3190
Description: Arm	Part Number:	D3204-3
Inspection Dwg: D3204	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>SD</u>	Audited by:	<u>E</u>	Prototype Approval:	N/A
Date:	05.07.07	Date:	25.07.08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue (P/O D3204-041)	KJ/JLM	<i>[Signature]</i>

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RELEASED
11/05/2022

DART AEROSPACE LTD	Work Order:	23190
Description: Arm	Part Number:	D3204-5
Inspection Dwg: D3204	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Same as
w/o 23524

Measured by:	<u>SD</u>	Audited by:	<u>EZ</u>	Prototype Approval:	N/A
Date:	05.07.08	Date:	05.07.08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue (P/O D3204-041)	KJ/JLM	<i>[Signature]</i>

RELEASED
10/05/2027

DART AEROSPACE LTD	Work Order:	23190
Description: Pedal	Part Number:	D3204-9
Inspection Dwg: D3204	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	BSL
Date:	05-07-09

Audited by:	
Date:	

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue (P/O D3204-041)	KJ/JLM	

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RELEASED
1/16/2024

DART AEROSPACE LTD	Work Order:	23190
Description: Plate	Part Number:	D3204-11
Inspection Dwg: D3204	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SD	Audited by:		Prototype Approval:	N/A
Date:	05.07.08	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue (P/O D3204-041)	KJ/JLM	JLM

RELEASED
07/05/2020

Job Costing Report

Dart Aerospace Ltd.
HawkesburyJul 06, 2005
01:05 pm

Work Order No : 0023190
 Project Name : D3204-041
 Project For : WK522
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3204-041
 Description : Pedal Assembly
 Manufactured : Yes
 Amount Req'd : 4
 Amount Done : 0
 Start Date : 05-05-05
 Est Finish Date : 05-31-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 *
 Est Mark Up : 0.000%
 Actual Mark Up : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	1.00	100.00		
Production Cost :	0.00	13.38	100.00	0.00	13.38
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	1.00	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	13.38	100.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	13.38			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	(-13.38)

DART AEROSPACE LTD	Work Order:	23190
Description: Bushing	Part Number:	D3204-7
Dwg: D3204 Rev. A page 2 Ref:	Qty:	4
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	RF	05/05/09	4
2	MC	Turn D3204-7 bushing as per Folio FA355 and Dwg D3204 Material: AISI 303 SS Ø0.50" Identify for D3204-7			
3	QC2	Inspect parts as they come off the CNC machine Identify as D3204-7			
4	MC	Deburr			
5	QC8	Second check			
6	MC	Go to D3204-041 for assembly			

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	
B	04.06.09	Change Step 6; remove Steps 7 & 8	KJ/RF RF	RF

RELEASED

RF 04.06.21

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

5/22

DART AEROSPACE LTD	Work Order:	23190
Description: Tube	Part Number:	D3204-1
Dwg: D3204 Rev. A page 2	Qty:	4
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	AP	05/05/09	4
2	MC	Turn D3204-1 tube as per Folio FA356 and Dwg D3204 Material: 6061-T6/-T62 (QQ-A-200/8) Ø0.750" x 0.125" wall (M6061T6T0.750W.125) Identify for D3204-1			
		Batch: M15072	JG	05/06/06	5
3	QC2	Inspect parts as they come off the CNC machine Identify as D3204-1	SG	05/06/06	5
4	MC	Deburr	SG	05/06/06	5
5	QC8	Second check	RE	05.06.06	5
6	MC	Go to D3204-041 for welding	GPL	05.07.12	5

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	
B	04.06.09	Change Step 6; remove Steps 7 & 8	KJ/RF RF	RF

RELEASED

RF 04-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	
Description: Tube	Part Number:	D3204-1
Inspection Dwg: D3204	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>S.G</u>	Audited by: <u>PC</u>	Prototype Approval:	N/A
Date: <u>05/06/06</u>	Date: <u>05.06.06</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue (P/O D3204- 1)	KJ/JLM	MM

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RELEASED
JUL 15 2027